

Date: Wednesday, 1/23/2008 12:06:36 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WELDMENT TOP PANEL	
Job Number : 36943	Part Number : D36505	
Estimate Number : 13030	Drawing Number : D3650 REV.B U/R	
P.O. Number :	Project Number : N/A	
This Issue : 1/23/2008 S.O. No. :	Drawing Revision : B U/R	
Prsht Rev. : NC	Material :	
First Issue : / / Type : SMALL /MED FAB	Due Date : 2/29/2008	Qty: 2 Um: Each
Previous Run : 35709		
Written By :		
Checked & Approved By :		
Comment : Est Rev:A New Issue 07-09-27 DD verified by: EC		
Est Rev:B ECN 1113P 08-01-22 DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S26GA	304/316 0.018 SHEET
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Comment: Qty.: 0.8537 sf(s)/Unit Total : 1.7073 sf(s)

304/316 SS sheet 26 ga (0.018" thick)

Batch: 106946 1B 8-2-4

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3650

Dwg Rev: B

Prog Rev: B

1B 8-2-4

②

2-Deburr if necessary

1B 8-2-4

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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1B 8-2-4

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

502/2/04 ②

5.0	BRAKE NC	NC BRAKE
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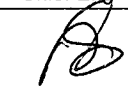
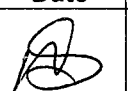
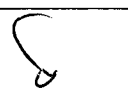
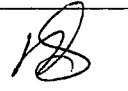
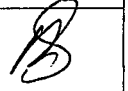
Comment: NC BRAKE

Form as per Dwg D3650

1B 08.03.12 ② PP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3650-5 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: N Date: 08/03/19
 QA: N/C Closed: _____ Date: _____

NCR: <u>36943</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
5	08-03-13	one scrap	 08/03/13	one scrap destruction QH (X)	 08-03-13	 08/03/14	 08/03/13	 08/03/13

NOTE: Date & initial all entries

Date: Wednesday, 1/23/2008 12:06:36 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WELDMENT TOP PANEL

Job Number: 36943

Part Number: D36505

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/14 (41)

7.0

D36507

SEAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

SEAL

batch ~~1106312~~ 35924

8.0

D36509

ANGLE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

ANGLE

batch ~~B 130321~~ 35414

08-03-13 ①

9.0

AN960C4

WASHER



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

WASHER

batch M106431

10.0

NAS9307M403

RIVET



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

RIVET

batch M105940

11.0

MS20427M33

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Rivet

batch M106993

12.0

MS210603K

Nut Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut Plate

batch M105938

08-03-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/23/2008 12:06:36 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WELDMENT TOP PANEL

Job Number: 36943

Part Number: D36505

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS210623K

Nut Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut Plate

batch 1105938

①

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg D3650

0803.13

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

0803.13
ENGINEERING
APPROVAL

0803.14 ①

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: MM 38103

0803.14 ①

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

0803.18 ①

Job Completion



0803.14
POSITIVE RECALL

EFFECTIVE 0801.21 AUTH U

RELEASED RT DATE 08.03.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

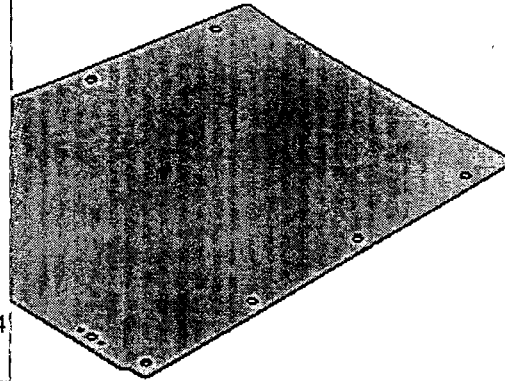
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D

D



1.14

0.344
(TYP)

Ø0.098 (40 DRILL)
(DIMPLE HOLES
FOR MS20427M3
RIVET (TYP)

8.34

Ø0.213 (TYP)

0.35 (TYP)

DETAIL G
(2 PLS)



C

C

B

B

1.17

0.351

Ø0.213 (TYP)

0.344

0.312

DETAIL H
(2 PLS)

PRELIMINARY ISSUE

VE 08.01.18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL
PER MIL-S-5019 (REF. DART S)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.6 lb

A

A

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D3650

REV. B

SHEET 8 OF 9

TITLE

TOP PANEL ASSEMBLY

SCALE

1:3

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MS21062-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(2 PLACES)

MS21060-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(2 PLACES)

PART LIST

QTY	PART NUMBER	DESCR
-5		
X	D3650-5	FWD PA 8.35
1	D3650-5B	FWD PA
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE 5B FWD PANEL BENT PART
		FROM D3650-5F FLAT PATTERN)
12	AN960C4	WASHE
12	CR3523-4-03 or NAS9307M-4-03	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLA
2	MS21062-3K	NUTPLA

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS ST
PER MIL-S-5019 (REF. DART
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNL
- 4) UNITS: INCHES UNLESS OTHERWISE
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.8 lbs

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D3650

REV. B

SHEET 7 OF 9

TITLE

TOP PANEL ASSEMBLY

SCALE

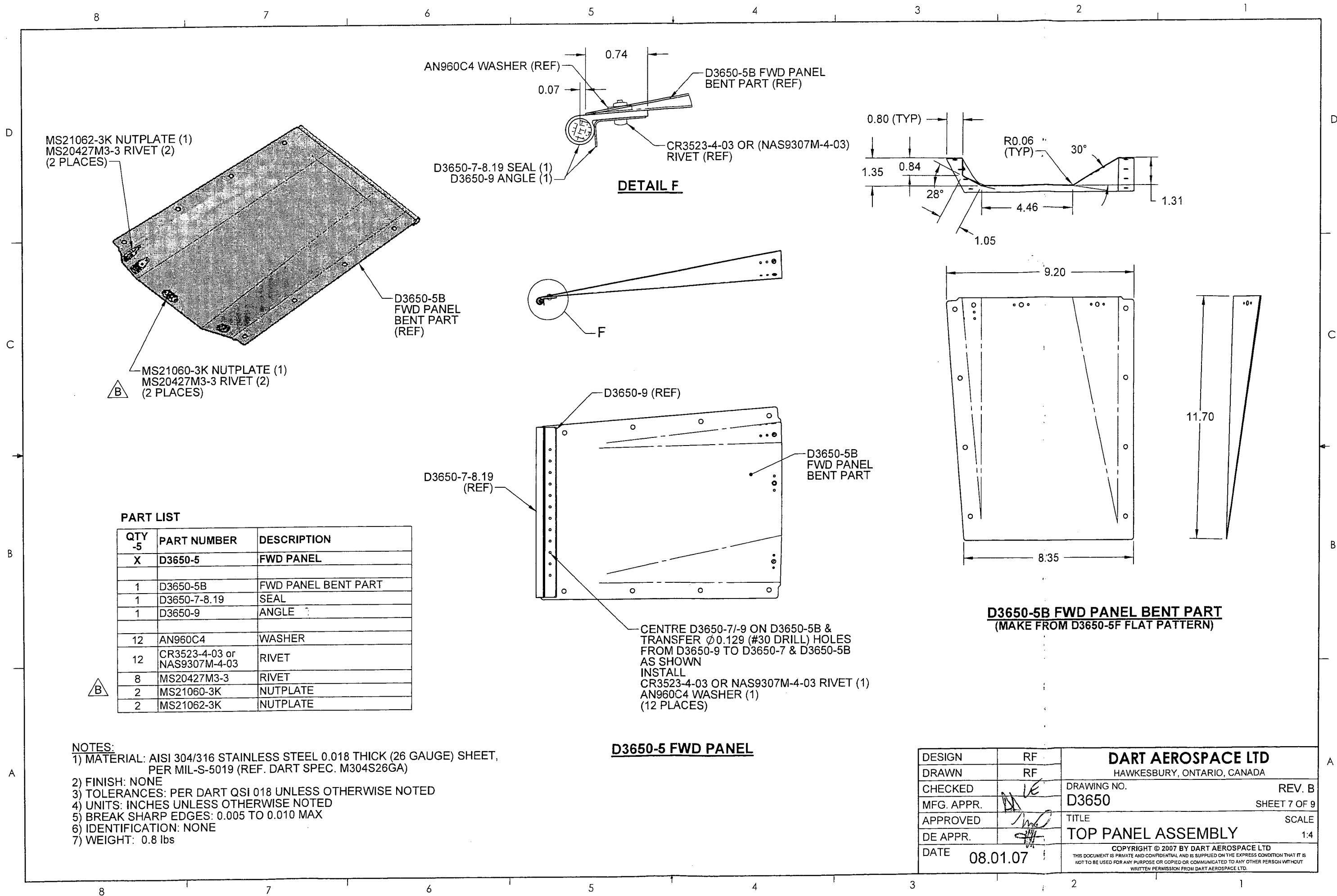
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PRELIMINARY ISSUE

LC 08-01-18



PART LIST





QTY	PART NUMBER	DESCRIPTION
-5	D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE
12	AN960C4	WASHER
12	CR3523-4-03 or NAS9307M-4-03	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE

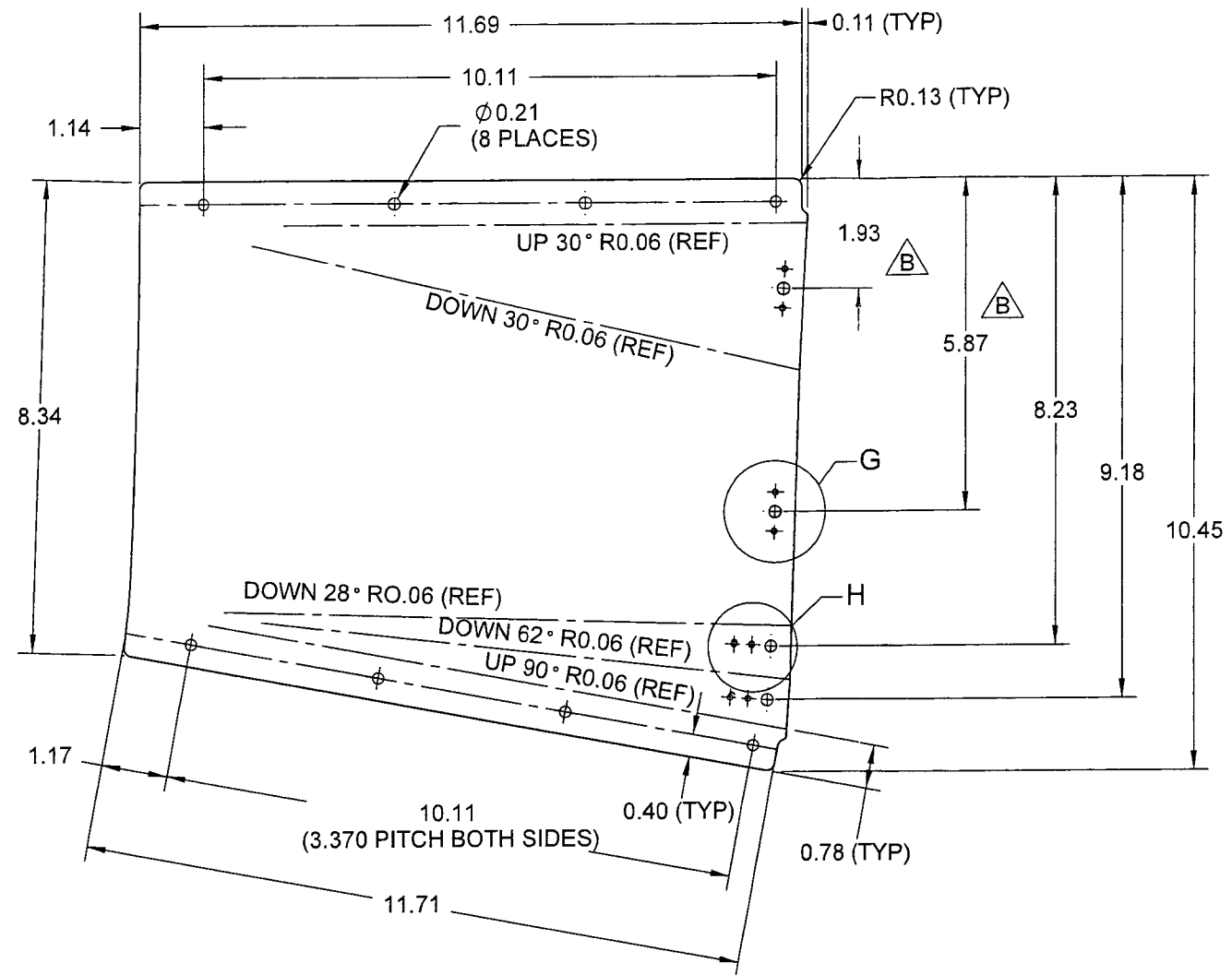
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.8 lbs

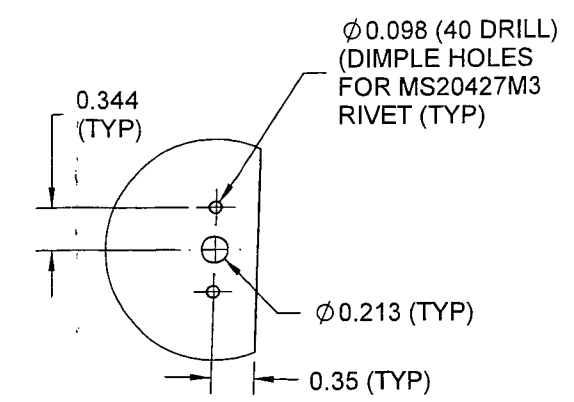
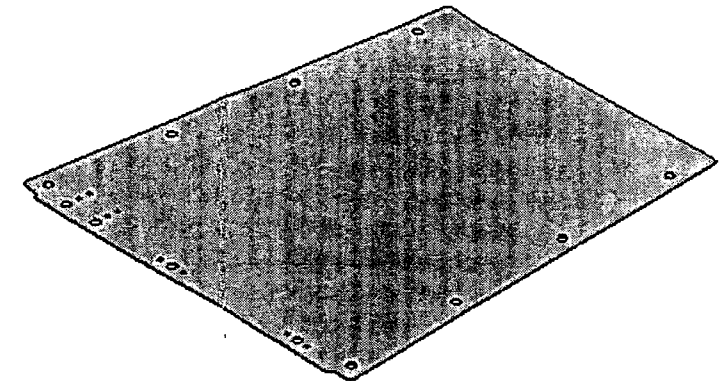
D3650-5 FWD PANEL

**D3650-5B FWD PANEL BENT PART
(MAKE FROM D3650-5F FLAT PATTERN)**

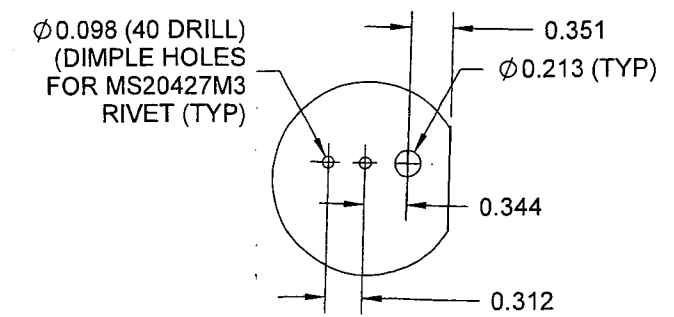
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3650	SHEET 7 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:4
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D3650-5F FLAT PATTERN



DETAIL G
(2 PLS)



DETAIL H
(2 PLS)

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- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.6 lb

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3650	SHEET 8 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:3
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